

Work Order ID 135825

August 20, 2015 2:36:35 PM

135825

LH Ship sep 3rd

Page 1

Item ID: D206-642-251

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Replacement Skidtube, High Gear with Run-on Landing Wearplates Fits LH or RH

Stop

NS2

Start Date: 8/20/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/31/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *SA*

Date: 0150820

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3804	A (DEO)								
IIN-D206-642	Q								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D206-642-251		CHG003						

N/A *[Signature]*

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Page 2

Item ID: D206-642-251

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N900040100Setup Start ***NS1***

Revision ID:

Item Name: Replacement Skidtube, High Gear with Run-on Landing Wearplates Fits LH or RH

Stop ***NS2***

Start Date: 8/20/2015 Start Qty: 1.00

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Cust Item ID:

Required Date: 8/31/2015 Req'd Qty: 1.00

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110

0.00

110

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Deburr Fwd edge of tube

2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804

3-Weld Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty Part Number Description Batch

A/R Aluminum Rod

4-Grind weld flush to cap on top surface only.

5-Cut Aft end as per dwg D3804 from front of tube and Deburr

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D3804

7-Open holes for Aft end cap as per Dwg D3804 with #30 Drill Bit using DT8025.

8-Drill pilot holes using Dt 8167, including #30 pilot at 1.25" from 15.450". Most fwd x-bolt hole must be laid out manually at 78.04".

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.

10- Drill D3286-1 doubler rivet holes in tube using # 40 drill, spot drilling doubler at the same time.

DOL 15-8-24

BE15-08-24

DP 15-8-24

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11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D3804

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

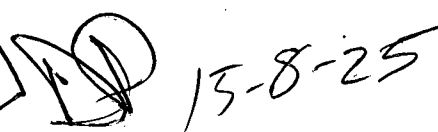
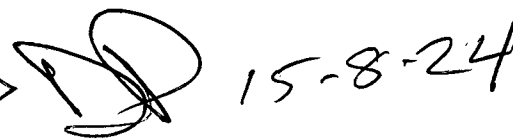
14-Remove indexing edge using DT8741 as per Dwg D3804. Leave 0.070" wall minimum.

15-C'sink GHW rivet holes as per Dwg D3804

16- Ream crossbolt holes to finish size as per dwg. ***DO NOT OPEN X-BOLT HOLES OF DETAIL "B".***

17- Open Aft cap hole #6.
****no wearplate holes for this skidtube****

18- Deburr tube and blow out chips from inside the tube



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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

0.00

160

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open holes to finished size to detail "B" as per Dwg D3804, (without cutting fluid)

2-C'sink ONE crossbolt spacer hole as per Dwg D3804 (Detail B)(without cutting fluid)

3-Deburr and blow out all chips from inside the tube



DAS
18
8-89

170

QC6- Inspect dimensions to drawing

0.00

170

QC

Memo

0.00

Quality Control



DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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OTHER : ☐																																																																				

Work Order ID 135825

135825

Page 6

August 20, 2015 2:36:35 PM

Item ID: D206-642-251 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Replacement Skidtube,High Gear with Run-on Landing Wearplates Fits LH or RH
 Start Date: 8/20/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 8/31/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180

180

Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required

2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up.Allow 12 Hrs. cure time before cutting

Start Date: 15-8-25 Time: 1230pm

Finish Date: Time: 15-8-25

Pick:

Qty Part NumberDescriptionBatch

A/RSikaflex-291 M132705

Sikaflex expire date: 16-2-12

190

190

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

DAS
18
9-89

1 0 8-15-08-26

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
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Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐								
		OTHER : _____							

Work Order ID 135825

August 20, 2015 2:36:36 PM

135825

Page

Item ID: D206-642-251

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Replacement Skidtube, High Gear with Run-on Landing Wearplates Fits LH or RH

Stop

NS2

Start Date: 8/20/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/31/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

0.00

200

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Remove alodine per DEO detail B from around hole and prepare for welding

2-Prep per QSI 005 and Insert one D2649 crossbolt spacer. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

QtyPart NumberDescriptionBatch

A/RAluminum Rod

M131560

3-Grind welds flush as per Dwg D3804.

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3804. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/RSS Rod

NONE

5-Insert D4720-1 Spacer. Swage to 0.313" X 0.75" DP per QSI 002. Trim and grind flush per QSI 002

6- Install D2680-041 Nut Plate as per Dwg D3804

7- Deburr

*BE15-08-27**15-8-26*

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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OTHER :																					

Work Order ID 135825

August 20, 2015 2:36:36 PM

135825

Page 8

Item ID: D206-642-251

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Replacement Skidtube, High Gear with Run-on Landing Wearplates Fits LH or RH

Start Date: 8/20/2015

Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/31/2015

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

QC9- Inspect visual per QSI004, Fusion Welds

0.00

220

QC

Quality Control

Memo

0.00

① 150827 PD

230

QC5- Inspect part completeness to step on W/O

0.00

230

QC

Quality Control

Memo

0.00

1 DAS 38 9-89

AUG 27 2015

240

Pressure Wash per QSI005 4.3

0.00

240

HandFinish

Hand Finishing

Memo

0.00

1 15-8-31 26L

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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OTHER : ☐																																																																									

Work Order ID 135825

135825

Page 9

August 20, 2015 2:36:36 PM

Item ID: D206-642-251 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Replacement Skidtube, High Gear with Run-on Landing Wearplates Fits LH or RH
Start Date: 8/20/2015 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 8/31/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250 *250* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs. m 131545 10:25. START TIME: OVEN TEMPERATURE: 320° FINISH TIME: 10:55.	0.00 0.00							1 ϕ 15.8-31 DAS 34 98
260 *260* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							164 ϕ 90 w/og DAS 15 98

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Work Order ID 135825

August 20, 2015 2:36:36 PM

135825 LH

Page 10

Item ID: D206-642-251

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Replacement Skidtube, High Gear with Run-on Landing Wearplates Fits LH or RH

Stop ***NS2***

Start Date: 8/20/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/31/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270	HandFinishing	0.00							
270									
HandFinish	Memo	0.00							
Hand Finishing	1-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D3804. Clean excess adhesive.								
280	HandFinishing	0.00							
280									
HandFinish	Memo	0.00							
Hand Finishing	1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive A/R Sikaflex-291 <u>M132705</u> Sikaflex expire date: <u>16162</u>								
	2- Install wearplate as per dwg <u>RTU 598 M131311 16/11</u>								
	2-Wing Walk as per Dwg D3804 and QSI 005 4.4 Batch: <u>M132589</u>								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 135825***135825***

Page 11

Item ID: D206-642-251

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Replacement Skidtube, High Gear with Run-on Landing Wearplates Fits LH or RH

Stop ***NS2***

Start Date: 8/20/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/31/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
290	QC3- Inspect Part Finish	0.00				1			DAS 38 7-89
290									
QC	Memo	0.00							
Quality Control									SEP 03 2015
300	QC5- Inspect part completeness to step on W/O	0.00				1			DAS 38 9-89
300									
QC	Memo	0.00							
Quality Control									SEP 03 2015
310	Packaging	0.00							DAS 02 9-89
310									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-251								
	Location: _____								
	PPP Rev: _____								SEP 03 2015

PPP B 135820

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 135825***135825***

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Item ID: D206-642-251

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Replacement Skidtube, High Gear with Run-on Landing Wearplates Fits LH or RH

Stop ***NS2***Start Date: 8/20/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 8/31/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

320

QC21- Final Inspection - Work Order Release

0.00

320

QC

Memo

0.00

Quality Control

15/9/3
mf
15-9-03

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Picklist Print

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Page 1

Work Order ID: 135825

135825

Parent Item: D206-642-251

D206-642-251

Parent Item Name: Replacement Skidtube, High Gear with Run-on Landing Wearplates Fits LH or RH

Start Date: 8/20/2015

Required Date: 8/31/2015

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP REV:A 11.11.17 PER IIN REVO DD VERF;EC
12.11.22 now swage per ecn12-679 DD verf:JLM
IPP Rev:C 14.04.25 ECN14-520 DD verf:JLM

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4720-1
D4720-1
Spacer

Manufactured No

200

Each

150.0000

19

19

**

Location

Loc Qty

Loc Code

LG001

150

129566

150

D2620

Manufactured No

110

Each

10.0000

1

**

Location

Loc Qty

Loc Code

LG002

10

126930

1

135726

4

135727

5

D3286-1

Manufactured No

110

Each

21.0000

2

2

**

D3286-1
Doubler

Location

Loc Qty

Loc Code

LG001

21

91158

21

D2647

Manufactured No

110

Each

18.0000

1

1

**

D2647
Cap

Location

Loc Qty

Loc Code

LG001

18

134879

18

DP 15-9-3

19

Doc 15-8-24

15-8-24

8815-0824

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Page 2

Work Order ID: 135825

135825

Parent Item: D206-642-251

D206-642-251

Parent Item Name: Replacement Skidtube, High Gear with Run-on Landing Wearplates Fits LH or RH

Start Date: 8/20/2015

Required Date: 8/31/2015

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-04

Purchased

No

180

Each

211.0000

52

CR3212-4-04

Cherry Rivet

**

DD 15-8-25

Location

Loc Qty

Loc Code

CCK004

162

m132317

162

LG001

49

m126534

49

D2654-3

Manufactured

No

180

Each

5.0000

1

D2654-3

Web

**

DD 15-8-25

Location

Loc Qty

Loc Code

LG002

5

112279

1

115653

4

D2649

Manufactured

No

200

Each

102.0000

1

D2649

Cross Bolt Spacer

**

BE15-08-27

Location

Loc Qty

Loc Code

LG

20

131103

20

LG001

82

132730

82

D3286-3

Manufactured

No

200

Each

68.0000

2

D3286-3

Spacer

**

BE15-08-27

Location

Loc Qty

Loc Code

LG001

68

09097

31

91160

37

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Work Order ID: 135825

135825

Parent Item: D206-642-251

D206-642-251

Parent Item Name: Replacement Skidtube, High Gear with Run-on Landing Wearplates Fits LH or RH

Start Date: 8/20/2015

Required Date: 8/31/2015

Start Qty: 1.00

Required Qty: 1.00

CCR264SS3-3 CCR264SS-3-03 Purchased No

CCR264SS3-3

Cherry Rivet

CR3212-4-03

Purchased No

CR3212-4-03

Cherry Rivet

M128606

Each 0.0000

** (2) DP 15-8-26

Location

Loc Qty

Loc Code

CCK004

500

119017

500

Each 16.0000

(2) DP 15-8-26

D2680-041

Manufactured No

D2680-041

Nut Plate

Location

Loc Qty

Loc Code

LG

16

129083

16

270 Each 7.0000

** (1) DP 15-8-26

D3805-043

Manufactured No

D3805-043

Run-on Landing Wearplate Fwd

Location

Loc Qty

Loc Code

FP001

3

134607

3

FP002

4

109265

3

134607

1

270 Each 3.0000

(1) DP 15-8-26

D3805-047

Manufactured No

D3805-047

Run-on Landing Wearplate Aft

Location

Loc Qty

Loc Code

FP001

3

133199

3

** (1) DP 15-8-26

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Shop Packet Print

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Page 4

Work Order ID: 135825

135825

Parent Item: D206-642-251

D206-642-251

Parent Item Name: Replacement Skidtube, High Gear with Run-on Landing Wearplates Fits LH or RH

Start Date: 8/20/2015

Required Date: 8/31/2015

Start Qty: 1.00

Required Qty: 1.00

AN3-37A

Purchased

No

270

Each

35.0000

7

7

AN3-37A

Bolt

**

15/09/02

Location

Loc Qty

Loc Code

FG

10

119086

10

FP001

14

m130325

14

ST347

11

m130466

11

NAS1149C0332R

Purchased

No

270

Each

4,913.000

7

7

NAS1149C0332R

WASHER

**

15/09/02

Location

Loc Qty

Loc Code

FP001

2140

m130325

2140

GA

221

m131618

221

ST260a

2000

m132930

2000

ST271

552

m129390

72

m132262

480

x7

Picklist Print

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Work Order ID: 135825

135825

Parent Item: D206-642-251

D206-642-251

Parent Item Name: Replacement Skidtube, High Gear with Run-on Landing Wearplates Fits LH or RH

Start Date: 8/20/2015

Required Date: 8/31/2015

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

270

Each

1,353.000

7

7

MS21042L3

Nut

all 15/09/02

Location

Loc Qty

Loc Code

FP001

393

M130922

393

KJ

GA

264

M131317

264

ST305

696

116549

12

126333

49

M128754

2

M132123

17

M132382

2

M132883

114

M132930

500

D3873-1

Manufactured

No

270

Each

18.0000

14

14

D3873-1

Bushing

all 15/09/02

Location

Loc Qty

Loc Code

FP001

2

126709

2

B135921

K14

ST063

16

134885

16

Picklist Print

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Page 6

Work Order ID: 135825

135825

Parent Item: D206-642-251

D206-642-251

Parent Item Name: Replacement Skidtube, High Gear with Run-on Landing Wearplates Fits LH or RH

Start Date: 8/20/2015

Required Date: 8/31/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0332J

Purchased

No

270

Each

2,078.000

2

2

NAS1149D0332.J

Washer

**

ll 15/09/16

Location

Loc Qty

Loc Code

CA

14

m129682

14

GA

568

m132677

568

ST269

1496

m130325

900

m131624

44

m132677

552

X2

MS27039-1-08

Purchased

No

270

Each

716.0000

2

2

MS27039-1-08

Screw

**

ll 15/09/16

Location

Loc Qty

Loc Code

CA

96

m128636

96

FP001

363

m128636

363

GA

2

125654

2

ST285

255

m128636

255

X2

D2651-1

Manufactured

No

270

Each

164.0000

8

8

D2651-1

Plug

**

ll 15/09/16

Location

Loc Qty

Loc Code

FP001

164

131695

30

132398

14

134571

120

X0

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Work Order ID: 135825

135825

Parent Item: D206-642-251

D206-642-251

Parent Item Name: Replacement Skidtube, High Gear with Run-on Landing Wearplates Fits LH or RH

Start Date: 8/20/2015

Required Date: 8/31/2015

Start Qty: 1.00

Required Qty: 1.00

D2651-3

Manufactured No

270 Each

224.0000 8 8

D2651-3

O-Ring

**

ll 15/09/02

Location

Loc Qty

Loc Code

FP001

224

113577

16

120110

208

x 2

MS27039-4-06

Purchased No

270 Each

100.0000 1 1

MS27039-4-06

Screw

**

ll 15/09/02

Location

Loc Qty

Loc Code

FP001

95

m132317

95

ST283

5

m126534

5

x 1

NAS1149D0463J

Purchased No

270 Each

2,760.000 1 1

NAS1149D0463.J

WASHER

**

ll 15/09/02

Location

Loc Qty

Loc Code

GA

41

M129390

41

ST260a

1000

M132677

1000

ST269

1719

M127904

20

M129682

86

M130799

371

M132035

1117

M132317

125

x 1

Picklist Print

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Work Order ID: 135825

135825

Parent Item: D206-642-251

D206-642-251

Parent Item Name: Replacement Skidtube, High Gear with Run-on Landing Wearplates Fits LH or RH

Start Date: 8/20/2015

Required Date: 8/31/2015

Start Qty: 1.00

Required Qty: 1.00

D2646

Manufactured No

280

Each

54.0000

1

1

D2646

Aft Cap

all is loged

Location

Loc Qty

Loc Code

FG

4

85848

2

90495

2

FP001

50

103306

1

114495

1

127924

4

128761

1

132325

16

132326

27

KL

ITEM	Qty -041	Qty -043	Part Number	Description
1	X		D3804-041	SKIDTUBE ASSEMBLY, 206 A/B LOW
2		X	D3804-043	SKIDTUBE ASSEMBLY, 206 A/B HIGH
5	1	1	D2600-1-160	EXTRUSION
6	1	1	D2646	AFT CAP
7	1	1	D2647	CAP
8	19	20	D2649	CROSS BOLT SPACER
9	6	8	D2651-1	PLUG
10	6	8	D2651-3	O-RING
11		1	D2654-3	WEB
12	1		D2654-1	WEB
13	1	1	D2680-041	NUT PLATE
14	2	2	D3286-1	DOUBLER
15	2	2	D3286-3	STUD
21	2	2	AN960JD10L	WASHER
22	1	1	AN960JD416	WASHER
23	2	2	CCR264SS3-3	RIVET
24	2	2	CR3212-4-03	RIVET
25	52	52	CR3212-4-04	RIVET
26	2	2	MS27039-1-08	SCREW
27	1	1	MS27039-4-06	SCREW

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 12.5 lb
- 9) WELD PER DART QSI 004
- 10) BENDING: DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

DEO ATTACHED

RELEASED

09.03.03
per ECN 09-536

20150A20
54 135825

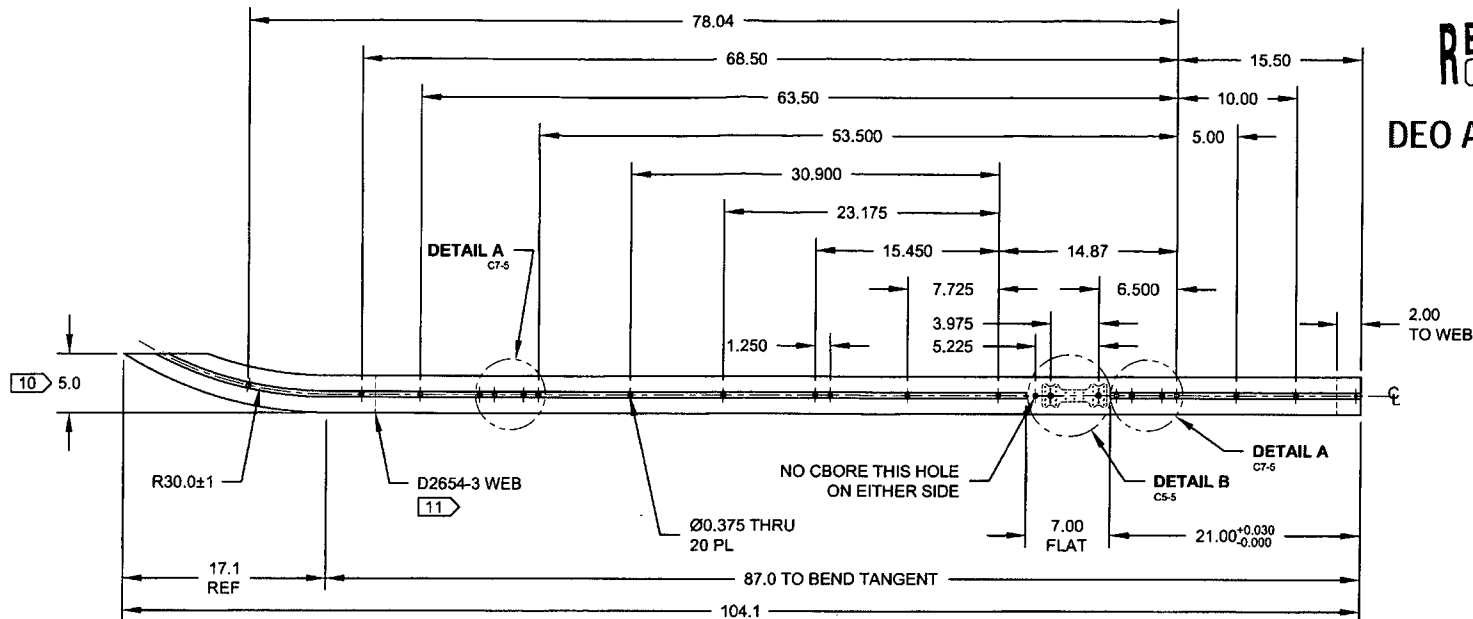
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REV.	DESCRIPTION	BY	DATE
DESIGN	97		
DRAWN	97		
CHECKED	97		
MFG. APPR.	97		
APPROVED	97		
DE APPR.	97		
DATE	08.07.07		

DART AEROSPACE USA, INC	
PORT HADLOCK, WA	
DRAWING NO.	REV. A
D3804	SHEET 1 OF 5
TITLE	SCALE
SKIDTUBE ASSEMBLY, 206A/B	NTS

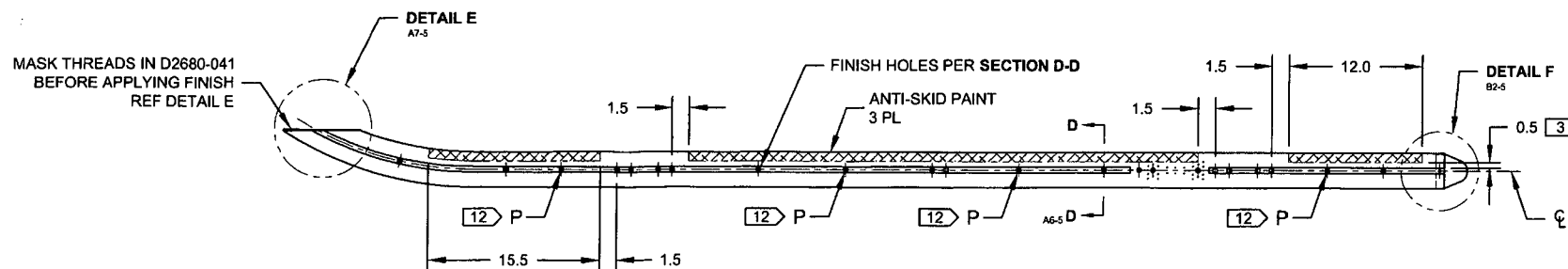
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RELEASED
(09-03-03)

DEO ATTACHED



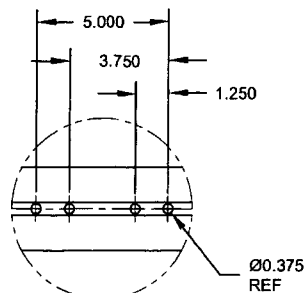
D3804-043 BENDING/DRILLING DETAIL



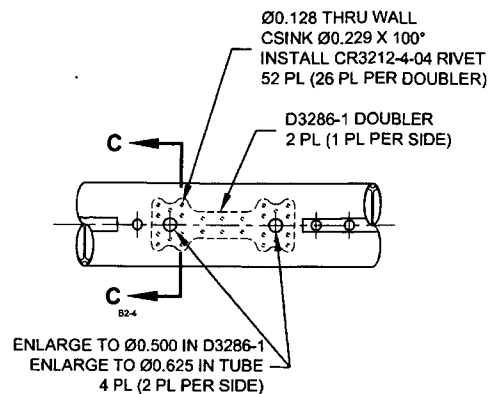
D3804-043 ASSEMBLY/FINISHING DETAIL

DESIGN	47	DART AEROSPACE USA, INC	
DRAWN	J	PORT HADLOCK, WA	
CHECKED	47	DRAWING NO.	REV. A
MFG. APPR.	B	D3804	SHEET 3 OF 5
APPROVED	140	TITLE	SCALE
DE APPR.	140	SKIDTUBE ASSEMBLY, 206A/B	NTS
DATE	08.07.07	COPYRIGHT © 2003 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

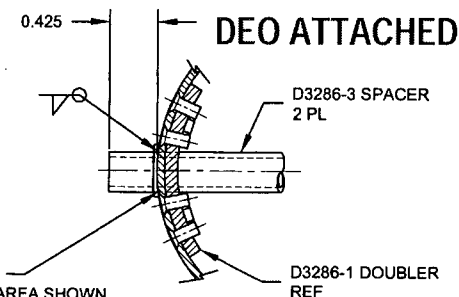
RELEASED
CP 09 03 03



DETAIL A D6-2
SCALE NONE C2-2
D6-3
C2-3

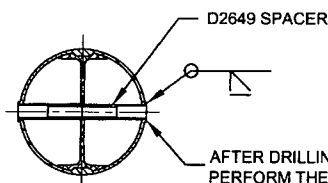


DETAIL B C3-2
SCALE NONE C3-3



- TO INSTALL D3286-1/-3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.03 X 45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH

SECTION C-C C6-4
PARTIAL SECTION
SCALE NONE



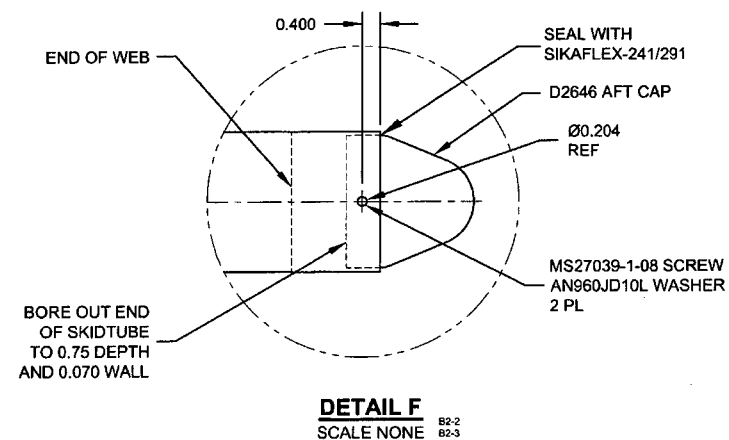
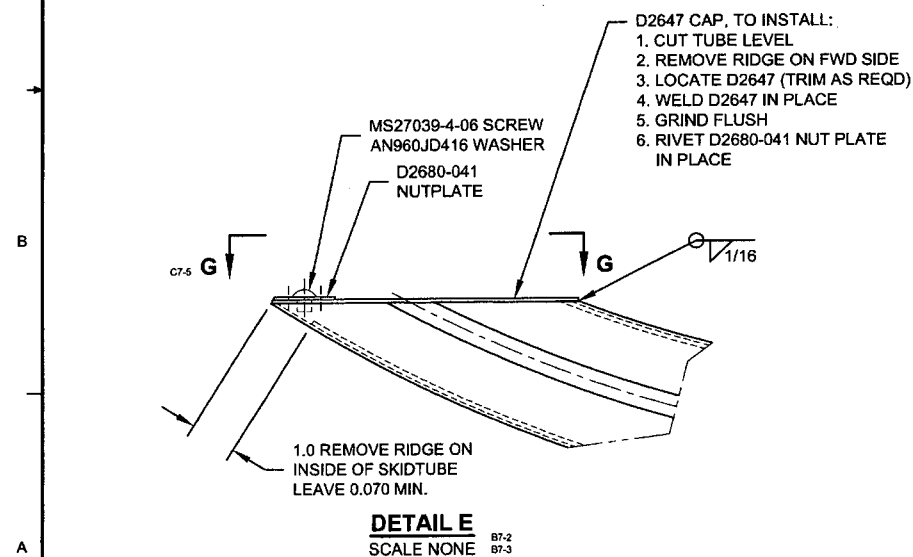
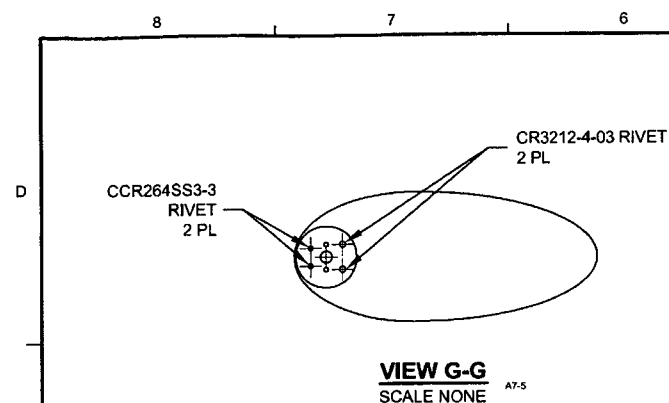
- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.03 X 45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. CBORE TO Ø0.313 X 0.75 DP (EXCEPT WHERE INDICATED)

SECTION D-D A4-2
FOR Ø0.375 HOLES ONLY A4-3
SCALE NONE

DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	97	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO. D3804	REV. A
MFG. APPR.	97	SHEET 4 OF 5	
APPROVED	97	TITLE	SCALE
DE APPR.	97	SKIDTUBE ASSEMBLY, 206A/B	NTS
DATE	08.07.07	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

RELEASED
99 09.03.02

DEO ATTACHED



DESIGN	99	DART AEROSPACE USA, INC	
DRAWN	J	PORT HADLOCK, WA	
CHECKED	99	DRAWING NO.	REV
MFG. APPR.	B	D3804	SHEET 5
APPROVED	99	TITLE	SC
DE APPR.	99	SKIDTUBE ASSEMBLY, 206A/B	
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DRAWING NO. D3804	TITLE SKIDTUBE ASSEMBLIES, 206A/B	REV. A	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3804-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>CP</i>	CHECKED <i>A.R.</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 12.10.12	DATE 12.10.22	DATE 12.10.22	DATE 12.10.22		DATE 12.10.22		

PURPOSE:

CHANGE C'BORED WELDED CROSSBOLT SPACERS TO SWAGED SPACERS

CHANGE:

PARTS LIST IS AMENDED AS FOLLOWS:

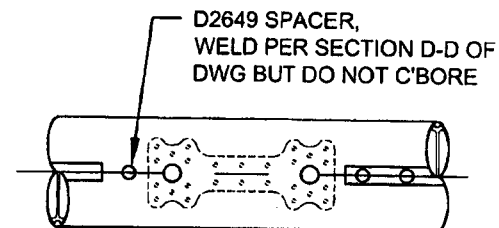
IS:

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-043		
1	1	D2649	CROSS BOLT SPACER
18	19	D4720-1	SPACER

WAS:

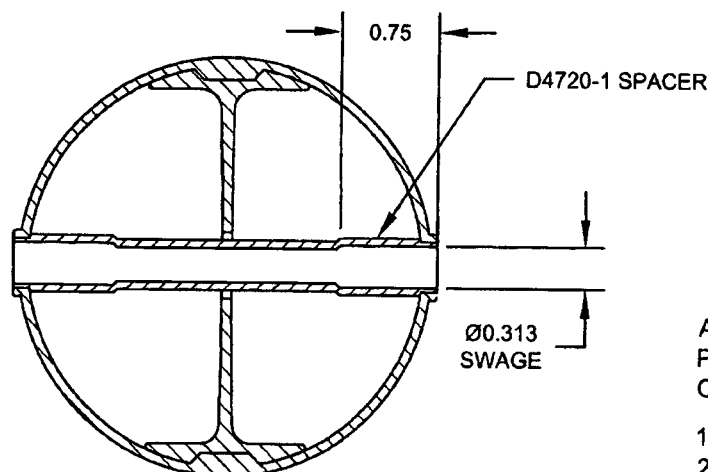
19	20	D2649	CROSS BOLT SPACER
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ADD SECTION H-H BELOW, WHICH IS THE SAME SECTION VIEW AS SECTION D-D OF DWG.
C'BORED HOLES ARE **NOW SWAGED** PER SECTION H-H BELOW. FOR THE Ø0.375 HOLE THAT IS NOT C'BORED, WELD PER SECTION D-D OF DWG (SEE AMENDED DETAIL B FOR REFERENCE).



DETAIL B

AMENDMENT TO DETAIL B
NOT TO SCALE



SECTION H-H

FOR Ø0.375 HOLES ONLY

FOR HOLES THAT ARE CURRENTLY C'BORED ONLY
NOT TO SCALE

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375 HOLES THAT ARE
CURRENTLY C'BORED:

1. INSERT D4720-1 SPACER, 18 PL (-041) OR 19 PL (-043)
2. SWAGE TO Ø0.313 X 0.75 DP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

RELEASE
2012-11-16
[Signature]